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D3290-1
Job Sheet 187236



Part No: D3290-1

Job Qty: 6 ea

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs	12/13/18	12/13/18	0.00	1.26	Waterjet - Flow		2019/02/25
120	QC	6 pcs	12/13/18	12/13/18	0.00	0.00	QC8		SC 19/02/26
130	HandFinish	6 pcs	12/13/18	12/13/18	0.00	0.41	HandFinish1		DR 18/2/26
135	QC	6 pcs	12/13/18	12/13/18	0.00	0.00	QC7-2		DR 19-02-27
140	Powdercoat	6 pcs	12/13/18	12/13/18	0.00	0.29	Powdercoat1		DR 19/02/27
150	QC	6 pcs	12/13/18	12/13/18	0.00	0.00	QC3		SC 19/02/27
180	Packaging	6 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-1	ST 432	FEB 28 2019
190	QC21-SA	6 Ea	12/13/18	12/13/18	0.00	0.00	QC21		21

M138247. START: 8:10 A.T. 3:00 FINISH: 8:40

9-55 MAR 01 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	22.5000 sf (3.75 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	23	174	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches ± 0.030	29.030 28.970		
2	Window Frame	14.000inches ± 0.030	14.030 13.970		
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170		
4	Window Frame	1.500inches ± 0.030	1.530 1.470		
5	Window Frame	1.110inches ± 0.030	1.140 1.080		
6	Window Frame	10.100inches ± 0.030	10.130 10.070		
7	Window Frame	18.500inches ± 0.030	18.530		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY		Other/Details:	

			18.470
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580

Plex 11/29/18 9:55 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS												
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐									
Date : _____ Description	Part: D3290-1 Job No: 187236 Serial No/Batch: S156329 Container No: S156329 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 02/25/19													
	MRB (QSI042) Completed By Lead hand / Supervisor QC / QA Coordinator													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">☐ Cracks</td> <td style="width: 33%;">☐ Broken/Damage/Defect</td> <td style="width: 33%;">☐ Weld</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> </tr> </table>	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	Large ☐ i ☐ n ☐ ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
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